Dart Aerospace Ltd. Thursday, 9/20/2007 3:26:35 PM User: Kim Johnston **Process Sheet** : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDE **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 34734 : 12933 **Estimate Number** : D29392UP : NA Part Number P.O. Number . D2939 REV C **Drawing Number** : 9/20/2007 S.O. No. : This Issue : N/A Project Number Prsht Rev. : MACHINED PARTS **Drawing Revision** First Issue Type : NV : 34195 Material Previous Run : 10/10/2007 8 Um: **Due Date** Written By Checked & Approved By New Issue 07-07-04 JLM Comment **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: 7075-T7351 2X6X6.25 D6101001 1.0 8.0000 Each(s) Comment: Qtv.: 1.0000 Each(s)/Unit Total: Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length Batch No: 13 3 4 6 4 3 HAAS CNC VERTICAL MACHINING # 2.0 HAAS1 Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 51 1-Inspect part number and batch number are programmed correctly. J.L. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 0411,23 5-Deburr CONVENTIONAL MILLING MACHINE 3.0 MILLING CONV

Each

4.0

QC1

Comment: CONVENTIONAL MILLING MACHINE

Comment: INSPECT ALL DIM TO DIM SHEET

Machine Keyway and inspect per attached dimension sheet

INSPECT ALL DIM TO DIM SHEET.

Da	rt A	ero	spa	се	Ltd
----	------	-----	-----	----	-----

part Ae	rospace L	ta 🦡					
W/O:		WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
;							
5							
Part No	:	PAR #: Fault Category:	NCR: Yes	Mo DQ	A: /	Date: _‹	<u>571/1/2</u> 8
			QA:	N/C Close	d:	_ Date: _	
NCR:		WORK ORDER NON-CONF	ORMANCE (NC	R)			

		WORK ORDE	ER NON-CONFORMAN	CE (NCR)				
	Description of NC	Corrective Action Section B				Approval	A =====1	
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto	
					,			
	STEP	STEP Description of NC	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng Corrective Action Section E Action Description Chief Eng	STEP Description of NC Section A Initial Chief Eng Chief	STEP Section A Initial Action Description Sign & Date Section C	STEP Description of NC Section A Initial Chief Eng Chief	

NOTE: Date & initial all entries

Thursday, 9/20/2007 3:26:35 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER Customer: CU-DAR001 Dart Helicopters Services **REVIEW** Part Number: D29392UP . Job Number: 34734 Job Number: Description: Seq. #: Machine Or Operation: SECOND CHECK 5.0 QC8 Comment: SECOND CHECK HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONV Comment: INSPECT POWDER COAT PACKAGING RESOURCE #1 8.0 PACKAGING 1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

9.0 QC21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W \$71128

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Dart Na		DAD # Foult Cotomony N	OD . V	No DO	_	Datas	

Part No: _	 PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	·		QA: N/C Closed:	Date:

	'	WORK OR	DER NON-CONFORMANC	E (NCR)							
	Description of NC		Corrective Action Section B		Verification	Approval	Approval				
STEP	STEP	SIEP	SIEP	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
			,	ı	·						
	•										
						İ					
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Section C Chief Eng				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34734
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

			ignted on inspe	· · · · · · · · · · · · · · · · · · ·	corded Actu				
Dim	Min	Max	Go/No Go Gauge	1 .	2	3	4	Ву	Date
, A	0.100	0.140		. 1/9	.128	,118	.// \		
В	0.100	0.140		-119	.115	.115_	.120		
С	0.100	0.140		-125	. 123	. 123	. 12.1		
D	0.210	0.230		.220	-221	220	.220		
E	1.245	1.255		1.258	1,250	1.208	1.250		
F	1.245	1.255		1,258	124	1-250	1.200		
G	2.495	2.505		2500	2.500	2.000	2.500		
Н	0.510	0.515		-510	. 560	-520	- S/C		
1	1.572	1.582		1.577	1.577	1.577	1517		
J	2.495	2.505		2,488	2501	2,500	2,502		
K	0.257	0.262		.258	.258	-258	.218		
L	0.312	0.317		. 3/4	- 374	-314	.314		2.55
М	0.235	0.240		-236	.238	-238	-236		
Ν	0.100	0.140		.121	./2/	. 122	.122		
0	0.540	0.560		-551	-351	-505	.556		
Р	0.490	0.510		000,	,501	-001	.500		
Q	3.715	3.725		7,720	3-120	3/120	3720		
R	2.720	2.760		2.743	2743	2743	2745		
S	0.240	0.270		,254	1253	. 254	259		
Τ	0.100	0.180		.145	-145	1745	1 . 173		
U	1.625	1.635		1630	1.630	1.630	1639		
٧	1.362	1.372	111111	1.368	1.368	8351	1368		
W	0.316	0.321	1/1/1/1	, 32a	. 320	320	. 3.20		
X	1.250	1.270	OP 81	1.238	1338	1253	1255		
Υ	1.565	1.585	DESCUE A/B	1.57,	1572	1.572	1.572		
Z	0.178	0.198		-188	-188	-188	-188		
AA									
AB									
AC						20.20			
AD							<u> </u>		
AE									
AF					, ,				
AG							,		
AH							,	,	
	Acc	ept/Reje	ct					4	

Measured by: S1	⁻ Audited by	- Cml	
Date: 07.1/.))	Date:	07/11/24	

Rev	Date	Change	Revised by	Approved
, A\		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	21
С	07.03.21	Revised per drawing revision C	KJ/JLM	



DART AEROSPACE LTD	Work Order:	34734
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

			-	Red	corded Actu	al Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1_	7.220	3	4	Ву	Date
A	0.100	0.140		-115	.118	1.118	-115		
В	0.100	0.140		119	-120	(1)	-115		
С	0.100	0.140		-120	1-123	.47	. 123		
D	0.210	0.230		1220	1500	.220	.22/		
E	1.245	1.255		1.258		1250	1.250		
F	1.245	1.255		1,250	1250	1.250	1250		
G	2.495	2.505		2.500	2,00	2200	2.500		
Н	0.510	0.515		,500	1500	, 50	-578		
	1.572	1.582		1,577	1-547	1.577	1.519		
J	2.495	2.505		2.501	2-500	2.502	2,00		
K	0.257	0.262		. 258	.258	.218	- 27X		
L	0.312	0.317		-314	-315	-714	-315		
М	0.235	0.240		-238	-528	· 5.28	238		
N	0.100	0.140		122	122	-122	, 122		
0	0.540	0.560		.556	556	558	222,		<u> </u>
Р	0.490	0.510		. SOO	, 500	. (0)	902		
Q	3.715	3.725		3,720	3, 720	3,720	3,720		
R	2.720	2.760		2.745	2.743	2.743	2443		
S	0.240	0.270		-253	252	.253	.253		
T	0.100	0.180	//	12-145	-143	-145	-150		
U	1.625	1.635	// . /	1.630	1630	1630	1630		
V	1.362	1.372	111	1.388	1.368	1.368	1.361		
W	0.316	0.321	NOW	.320	-320	1320	, 320		
Х	1.250	1.270	C/2 10	1.250	1.259	1.255	1260		
Υ	1.565	.1.585	DT8895-A/B.	1.571	1-572	1572	1.573		
Z	0.178	0.198		188	188	88.	188		
AA									
AB			10 000						
AC							*		
AD		··.		-			·		-
AE									
AF									
AG									
AH									
	Acc	ept/Reje	ct						

,			
Measured by:	17	Audited by	CML.
Date:	07.11.73	Date:	07/11/24
			· · · · · · · · · · · · · · · · · · ·

Rev	Date	Change	Revised by	Approved
A.		New Issue /		
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
С	07.03.21	Revised per drawing revision C	KJ/JLM	



